

Work Order ID 56038

Tuesday, February 09, 2010 11:41:17 AM

Page 1

Item ID: DSK076

Accept

Revision ID:

Item Name: D2891-1 TURNING DETAIL

Start Date: 2/10/2010 Start Qty: 10.00

Required Date: 2/23/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: MF

Date: 10-2-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSK076

Rev A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn blank for as per Folio FA046

SL 10/02/22

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/02/22

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S.F 10/02/22

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56038

Tuesday, February 09, 2010 11:41:17 AM

Page 2

Item ID: DSK076

Accept

Setup Start

Revision ID:

Stop

Item Name: D2891-1 TURNING DETAIL

Start Date: 2/10/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 2/23/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: C.N.C

L.F 10/02/22

10

/

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/02/23

MF
10-2-23

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Tuesday, February 09, 2010 11:41:17 AM

Page 1

Work Order ID: 56038



Parent Item: DSK076



Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 2/10/2010

Required Date: 2/23/2010

Comments: IPP rev A. 08.03.13 new issue EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6104-003		Manufactured	No				Each	20.0000	10.0000			
Round Billet, 17-4												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20

53750

20

10 SL 10/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56038
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.2765	2.276	2.277	2.276	2.2755
B	3.702	3.722		3.711	3.714	3.711	3.712	3.715
C	2.564	2.584		2.575	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.475	2.474	2.474	2.474	2.474
G	2.029	2.049		2.038	2.038	2.038	2.038	2.038
H	2.964	2.984		2.975	2.974	2.974	2.974	2.974
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.099	.099	.098	.099	.100
L								
M								
N								
O								
P								

Measured by:	SL	Date:	10/02/22
Audited by:	SP	Date:	10/02/22
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56032
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
Lathe Section								
A	2.274	2.279		2.277	2.277	2.277	2.2775	2.277
B	3.702	3.722		3.713	3.713	3.715	3.711	3.713
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.038	2.038	2.038	2.038	2.038
H	2.964	2.984		2.974	2.974	2.974	2.974	2.974
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110						
L								
M								
N								
O								
P								

Measured by:	SL	Date:	10/02/22
Audited by:	BP	Date:	10/02/22
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

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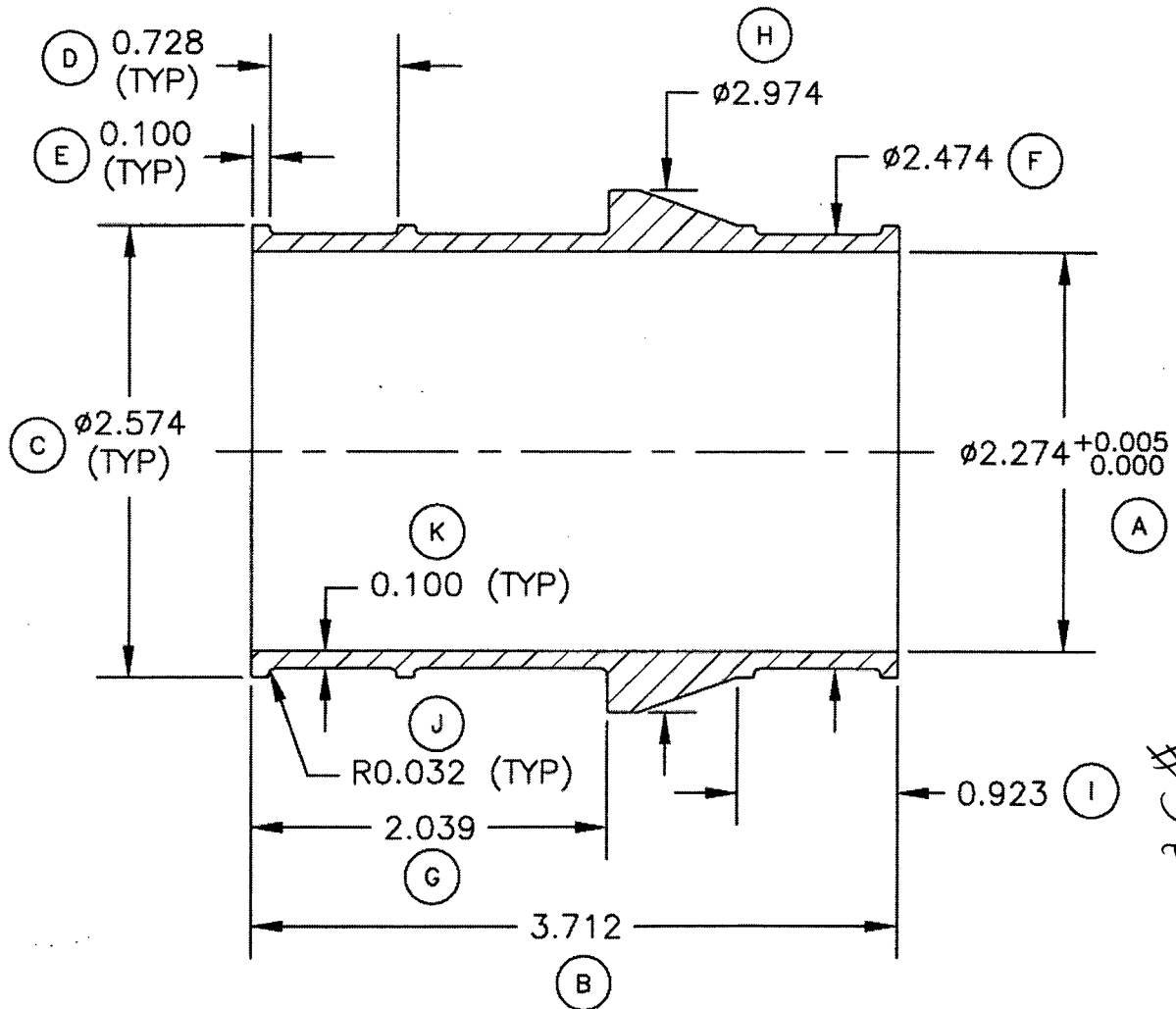
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DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 CH



D2891-1 TURNING DETAIL

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#56038

2.276

3.560

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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